



Dart Aerospace Ltd.  
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Canada

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**D3290-1**

**Job Sheet 177045**



Part No: D3290-1

Job Qty: 6 ea

Part Name: Frame



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/4/18

Job Tracking No:

Due Date: 5/24/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV C IPP REV:A 12.06.13 NEW ISSUE DD VERF:EC

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off        |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-----------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                 |
| 90    | Start up Operation | 6 Ea  | 5/24/18    | 5/24/18  | 0.00      | 0.00    | Start Up Waterjet     |           | SC 18/05/13     |
| 100   | Waterjet           | 6 pcs | 5/24/18    | 5/24/18  | 0.00      | 1.26    | Waterjet1             |           | SC 18/05/13     |
| 120   | QC                 | 6 pcs | 5/24/18    | 5/24/18  | 0.00      | 0.00    | QC8                   |           | 1138            |
| 130   | HandFinish         | 6 pcs | 5/24/18    | 5/24/18  | 0.00      | 0.41    | HandFinish1           |           | SA 18-05-29     |
| 135   | QC                 | 6 pcs | 5/24/18    | 5/24/18  | 0.00      | 0.00    | QC7-2                 |           | BR 15-5-29      |
| 140   | Powdercoat         | 6 pcs | 5/24/18    | 5/24/18  | 0.00      | 0.29    | Powdercoat1           |           | BR 15-5-29      |
| 150   | QC                 | 6 pcs | 5/24/18    | 5/24/18  | 0.00      | 0.00    | QC3                   |           | 1 MAY 29 2018   |
| 180   | Packaging          | 6 pcs | 5/24/18    | 5/24/18  | 0.00      | 0.00    | Packaging3-1          |           | 9-8 JUN 01 2018 |
| 190   | QC21-SA            | 6 Ea  | 5/24/18    | 5/24/18  | 0.00      | 0.00    | QC21                  |           | 9-8 JUN 01 2018 |

M 138859

START 2:00

OV.T: 300° FINISH 2:30

### Job BOM

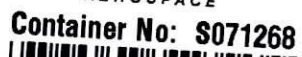
| Part / Item  | Component Name     | Quantity             | Operation             | Container |
|--------------|--------------------|----------------------|-----------------------|-----------|
| M6061T6S.063 | 6061-T6 .063 Sheet | 22.5000 sf (3.75 ea) | 90-Start up Operation |           |

5042200  
2008 9814

5055004

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | M6061T6S.063   | 23       | 181       | 0         |



Part: D3200 1

Part: D3290-1

Job No: 177045

Serial No/Batch: S071268

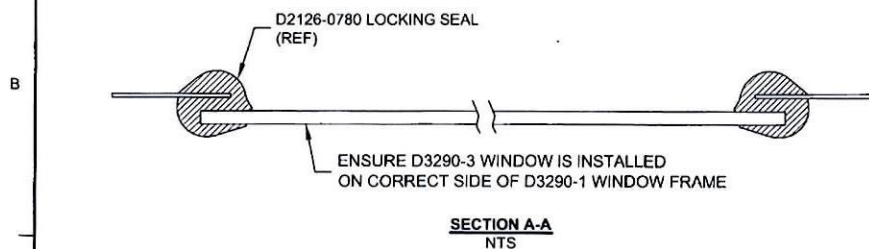
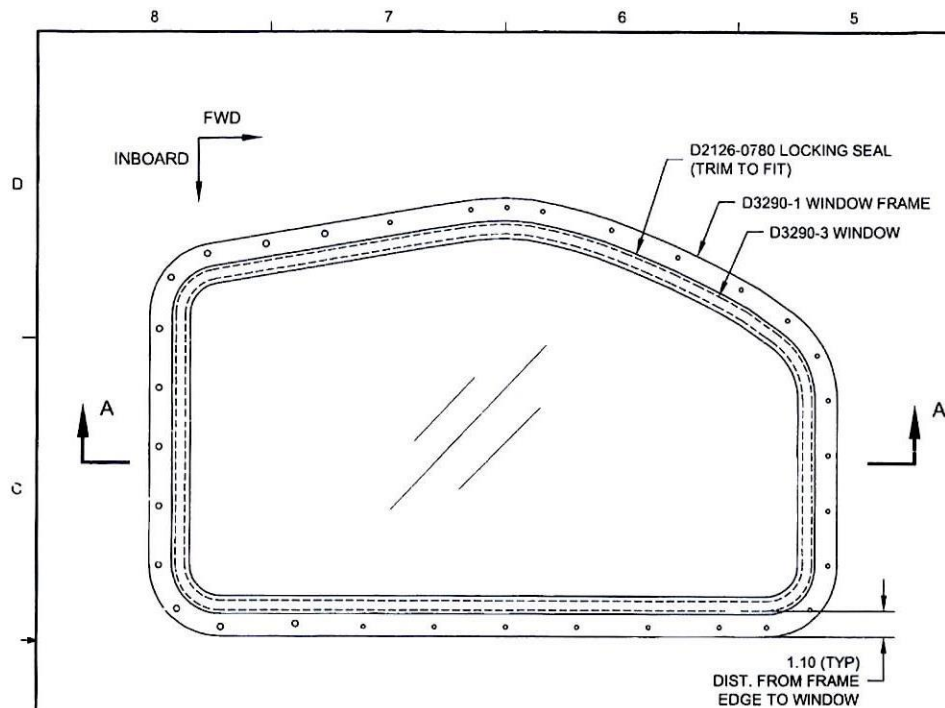
Revision:

Inspector:

Date: 05/14/18

| Part Specifications |              |                                    |                  |        |                  |
|---------------------|--------------|------------------------------------|------------------|--------|------------------|
| Spec No             | Description  | Target/Tolerance                   | Limits           | Type   | Special Comments |
| 1                   | Window Frame | 29.000inches $\pm$ 0.030           | 29.030<br>28.970 | 29,000 |                  |
| 2                   | Window Frame | 14.000inches $\pm$ 0.030           | 14.030<br>13.970 | 14,000 |                  |
| 3                   | Window Frame | 0.171inches $\pm$ 0.005<br>- 0.001 | 0.176<br>0.170   | 0,172  |                  |
| 4                   | Window Frame | 1.500inches $\pm$ 0.030            | 1.530<br>1.470   | 1,502  |                  |
| 5                   | Window Frame | 1.110inches $\pm$ 0.030            | 1.140<br>1.080   | 1,112  |                  |
| 6                   | Window Frame | 10.100inches $\pm$ 0.030           | 10.130<br>10.070 | 10,100 |                  |
| 7                   | Window Frame | 18.500inches $\pm$ 0.030           | 18.530<br>18.470 | 18,500 |                  |
| 8                   | Window Frame | 0.063inches $\pm$ 0.010            | 0.073<br>0.053   | 0,063  |                  |
| 9                   | Window Frame | 3.000inches $\pm$ 0.030            | 3.030<br>2.970   | 3,001  |                  |
| 10                  | Window Frame | 4.500inches $\pm$ 0.030            | 4.530<br>4.470   | 4,503  |                  |
| 11                  | Window Frame | 0.257inches $\pm$ 0.006<br>- 0.001 | 0.263<br>0.256   | 0,258  |                  |
| 12                  | Window Frame | 13.610inches $\pm$ 0.030           | 13.640<br>13.580 | 13,610 |                  |

Plex 5/4/18 12:45 PM Dart.Gagnon.Michelle

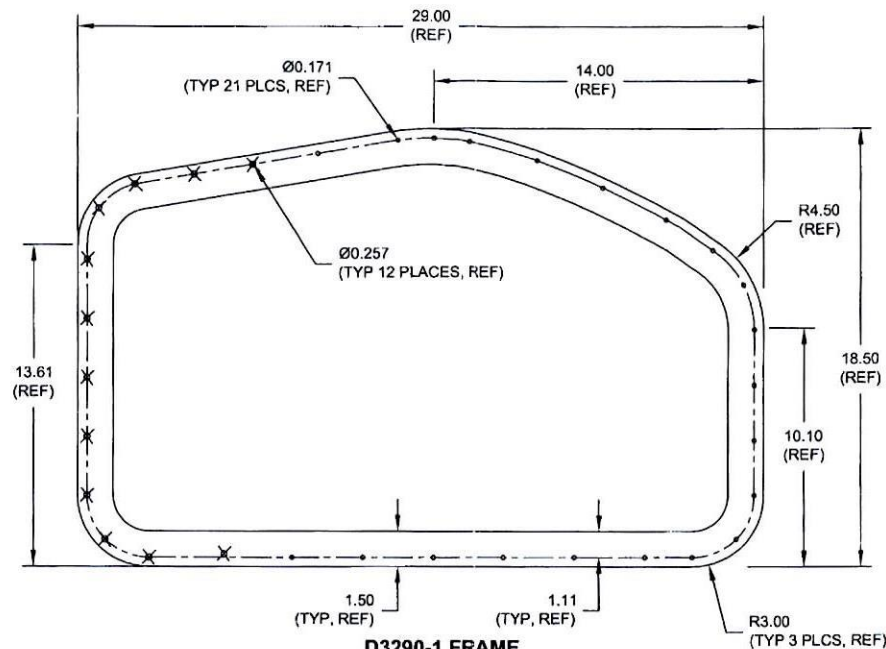


### D3290-041 REPLACEMENT WINDOW ASSEMBLY

**D3290-041 NOTES:**  
1) WEIGHT: 3.66 LBS

**GENERAL NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED



### D3290-1 FRAME

**D3290-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)  
OR  
5052-H32 ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/8 OR AMS 4016 (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

**RELEASED**  
07.07.24  
**DEO ATTACHED**

**UNDER REVIEW**

4/07.07.18  
7/15 07-05  
6/17/19

|            |                             |    |          |
|------------|-----------------------------|----|----------|
| C          | UPDATE DIMS PER PAR 188     | DC | 07.07.24 |
| B          | UPDATE MATERIAL PER NCR 029 | MB | 06.04.20 |
| A          | NEW ISSUE                   | RF | 04.06.14 |
| REV.       | DESCRIPTION                 | BY | DATE     |
| DESIGN     |                             |    |          |
| DRAWN      |                             |    |          |
| CHECKED    |                             |    |          |
| MFG. APPR. |                             |    |          |
| APPROVED   |                             |    |          |
| DE APPR.   |                             |    |          |
| DATE       | 07.07.24                    |    |          |

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3290  
REV. C  
SHEET 1 OF 2  
TITLE  
REPLACEMENT WINDOW ASSEMBLY  
SCALE 1:5

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